

# Work Order ID 62105

Thursday, September 16, 2010 8:32:38 AM



Page 1

Item ID: PB67-43001-203

Accept



Setup Start



Revision ID:

Item Name: Square Tube

Stop



Start Date: 9/16/2010 Start Qty: 8.00

Required Date: 9/30/2010 Req'd Qty: 8.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan: *mf*

Date: 10-9-15

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
B67-43001	C

100



Small Fab

Small Fab

Small Fab

Memo

1- cut to length as per dwg  
2- deburr

0.00

0.00

*10-09-21*

*8*

*φ*

110



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

*8/10/21*

*(28)*

120



Mill Conv

Conventional Milling Machine

CONVENTIONAL MILLING MACHINE

Memo

1- drill holes as per dwg  
2- make a chamfer on both side of the 2 holes as per dwg  
3- deburr

0.00

0.00

*10/02/26*

*8*

*φ*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Work Order ID 62105

Thursday, September 16, 2010 8:32:38 AM

Page 2

Item ID: PB67-43001-203

Accept

Setup Start

Revision ID:

Stop

Item Name: Square Tube

Start Date: 9/16/2010 Start Qty: 4.00

Cust Item ID:

Required Date: 9/30/2010 Req'd Qty: 4.00

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00 0.00				8			
140 Large Fab Large Fab	Weld per dwg A/R Aluminum rod Batch: M112360 m114817  Memo 1- Weld assembly as per dwg	0.00 0.00				8			
150 Small Fab Small Fab Small Fab	Small Fab  Memo 1- grind weld flush 2- deburr	0.00 0.00				8			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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**Work Order ID 62105**

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Page 3

Item ID: PB67-43001-203

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Revision ID:

Item Name: Square Tube

Start Date: 9/16/2010 Start Qty: 4.00

Required Date: 9/30/2010 Req'd Qty: 4.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160



QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

0.00

Memo

0.00

S.10/09/27

170



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

S.10/09/27

(X8)

180



Packaging

Packaging

Identify as per dwg &amp; Stock Location: 437

0.00

Memo

0.00

C.10/09/27 (C)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

**Work Order ID 62105**

Thursday, September 16, 2010 8:32:38 AM

Page 4

Item ID: PB67-43001-203

Accept

Revision ID:

Item Name: Square Tube

Start Date: 9/16/2010 Start Qty: 4.00

Required Date: 9/30/2010 Req'd Qty: 4.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/09/28 JF

10/8-9-28  
(5)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

Thursday, September 16, 2010 8:32:37 AM

Page 1

Work Order ID: 62105

Parent Item: PB67-43001-203

Parent Item Name: Square Tube

Start Date: 9/16/2010

Required Date: 9/30/2010

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A 08-06-26 new issue DD verified by:ec

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6TS1.000W.12 0		Purchased	No			100	f	138.8815	1.6042	6.754526			



6061T6 SQ TUBE 1.00 x 1.00 X .120w



10.09.21

Location

Loc Qty

Loc Code

MAT015

138.8815

108876

80

110680

58.8815

8

PB67-43001-227

Manufactured

No

140

Each

54.0000

2

8



Bushing



10.09.27

Location

Loc Qty

Loc Code

ST438

54

43712

22

44987

32

16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



8

7

6

5

4

3

2

1

D

C

B

A

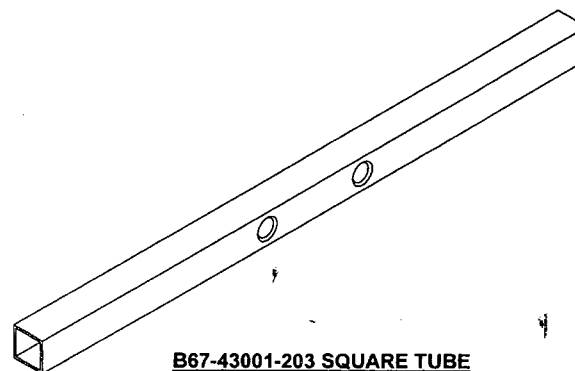
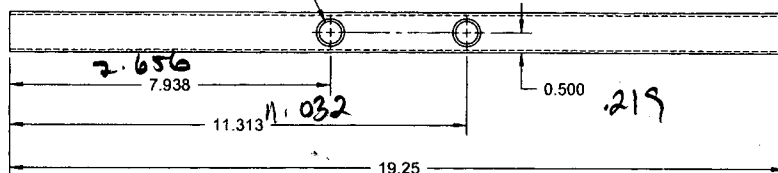
D

C

B

A

Ø0.563 THRU  
Ø0.693 X 45° CHAMFER  
TYP, BOTH SIDES  
2 PL



B67-43001-203 SQUARE TUBE



0.065 ±0.012  
TYP, REF  
0.120  
TYP, REF  
1.00  
TYP, REF

#62103

RELEASED  
2009-09-24

## NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) SQUARE TUBING  
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR  
PER AMS-QQ-A-200/8 (OR AMS 4160)  
REF. DART SPEC. M6061T6TS1.000W0.065 ±0.012 M6061T6TS1.000W0.120
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.45 lbs

C	REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018 AND QSI 043. FOR PREVIOUS REVISIONS, REFER TO PAGE 16 OF PREMIER AVIATION DRAWING No. B67-43001. REASON: SEE PAR#09-011.		MB	09.02.19
REV.	DESCRIPTION		BY	DATE
DESIGN	RW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	LS			
CHECKED	AS	DRAWING NO.	REV. C	
MFG. APPR.	LS	B67-43001-203	SHEET 1 OF 1	
APPROVED	LS	TITLE	SCALE	
DE APPR.	N/A	SQUARE TUBE	NTS	
DATE	09.02.19	COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		

W/O:		WORK ORDER CHANGES					
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries